Dart Aerospace Ltd.

Friday, 28/11/2008 3:05:27 PM

Date: User: Julie Dawson **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : ANGLE Job Number : 43860-Estimate Number : 10865 P.O. Number Part Number : D31711 This Issue : 28/11/2008 S.O. No. : **Drawing Number** : D3171 : NC Prsht Rev. Project Number : N/A First Issue : 11 : SMALL /MED FAB Type **Drawing Revision** : A : 38176 Previous Run Material **Due Date** Written By : 10/12/2008 Qty: 10 Um: Each Checked & Approved By Comment New Issue KJ ESt Rev:B 08-03-27 now on water jet DD verified by: **Additional Product** Job Number: Seq. #: Machine Or Operation: Description: 1.0 M304S16GA 304/316 Sheet .063 Comment: Qty.: 0.0216 sf(s)/Unit Total: 0.2163 sf(s) 304/316 .063 Sheet batch: 108734 B 8-12-8 2.0 WATER JET FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3171 188-17-8 Dwg Rev: Prog Rev: 2-Deburr if necessary 3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE B 8-4-8

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

5.0

QC8

SECOND CHECK

SMALL & MEDIUM FAB RESOURCE 1



Comment: SECOND CHECK



SMALL FAB 1



Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary





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W/O:			WORK OF	RDER CHANGE	S				
DATE	STEP	PR	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	
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NOTE: Date & initial all entries

Date: Friday, 28/11/2008 3:05:27 PM Julie Dawson User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: ANGLE Job Number: 43860 Part Number: D31711 Job Number: Seq. #: Machine Or Operation: Description: 6.0 BRAKE NC NC BRAKE Comment: NC BRAKE Bend as per Dwg D3171 Tumble QC5 7.0 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 8.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 9.0 QC21 198/12/109 Comment: FINAL INSPECTION/W/O RELEASE 08-12-00 Job Completion

Form: rprocess

Page 2

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NCR:	3	WORK ORDER NON-CONFORMANCE (NCR)									
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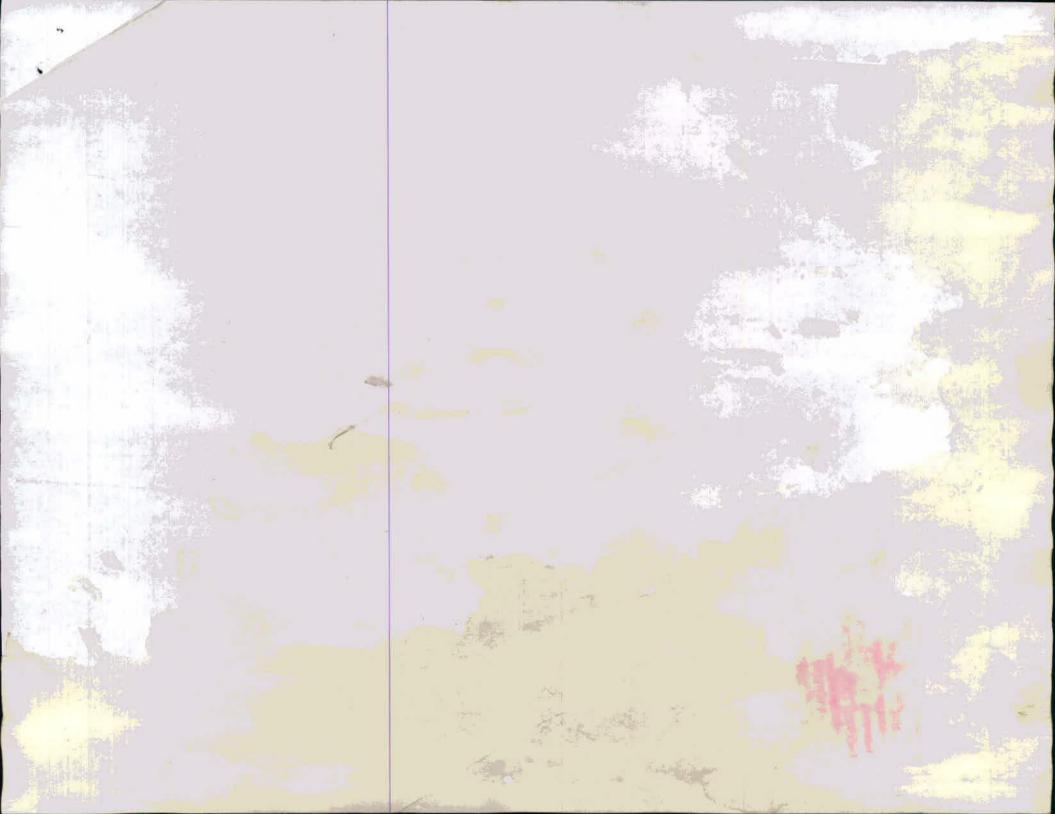
NOTE: Date & initial all entries

DART AEROSPACE LTD Work Order: 3860 Description: Angle Part Number: D3171-1 Inspection Dwg: D3171 Rev: A Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500	+0.006/-0.001	1500	×	100		
Ø0.257	+0.006/-0.001	1256	8			By Lasten
2.517	+/-0.010	2.517	*			
1.180	+/-0.010	11993	2			
1.527	+/-0.010	1.527	y			
0.400	+/-0.010	4.00	8			
0.590	+/-0.010	-591	9			
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easured by:	B	Audited by:	15		Prototype App	roval: N/A
Date:	8-13-8	Date:	08/6	206		Date: N/A

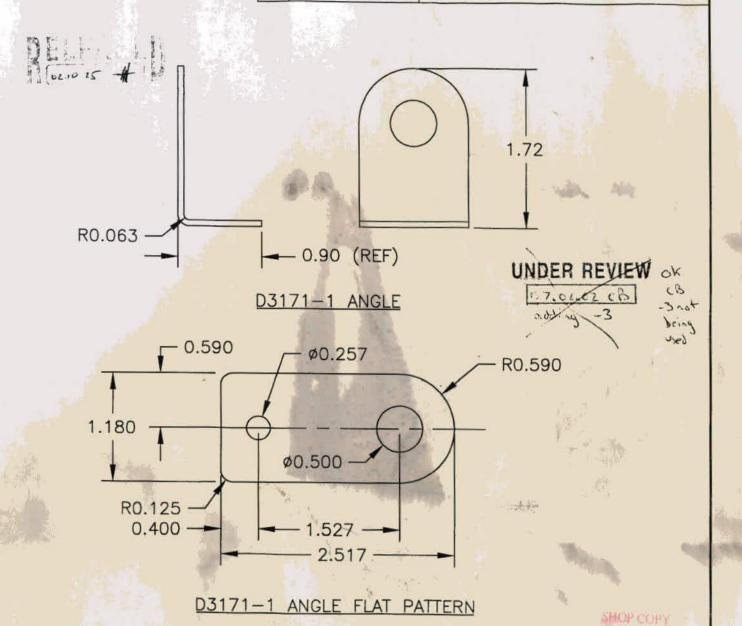
H-\FORMS\Quality	Assurance\approved OA\F	Al revD







DESIGN	DRAWN BY		SPACE LTD
CHECKED	APPROVED	DRAWING NO. D3171	REV. A SHEET 1 OF 1
02.10.08	8	TITLE ANGLE	SCALE 1:1
A	02.10.08	NEW ISSUE	



NOTES

1) MATERIAL: AISI 304/316 ANNEALED SS SHEET 0.063 THICKUNCONTRO PER MIL-S-5019 (REF. DART SPEC. M304S16GA)

TOLERANCES ARE PÈR DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

BREAK ALL SHARP EDGES 0.005 TO 0.010

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